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D4635-041
Job Sheet 185046



006767

Part No: D4635-041

Job Qty: 1 ea

Part Name: Fwd Ceiling Panel Assembly, LH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/22/18

Job Tracking No:

Due Date: 11/30/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: D4635 REV.F IPP Rev. A 12/08/09 New Issue DL IPP Rev B 12/11/08 Doc Release DL IPP Rev. C Dwg.
Update 13/07/09 DL verf: DD IPP Rev D Dwg Update 13/12/09 DL Ipp Rev. E Dwg Update 14/01/09 DL IPP
Rev. F Dwg. Update 15/01/27 DL

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		11/30/18	0.00	0.00	Start Up Small Fab		Smb
100	Small Fab	1 pcs		11/30/18	0.00	1.00	Small Fab		NTR.
110	Small Fab	1 pcs		11/30/18	0.00	0.00	Small Fab		Smb
120	QC	1 pcs		11/30/18	0.00	0.00	QC5		38
130	Packaging	1 pcs		11/30/18	0.00	0.00	Packaging3		DEC 07 2018
140	QC21-SA	1 Ea		11/30/18	0.00	0.00	QC21		DEC 07 2018

Part Op 100 - *** APPLY A 3/16" SEEM OF PLASTIC-WELD 2 ON TOTAL LENGTH OF PART ON EACH SIDE OF LIGHT, LET
Descriptions: DRY FOR ONE HOUR*** PLASTIC-WELD 2 BATCH: 5138996 1- Assemble as per Dwg D4635-041 2-
Install No Smoking & Seat belt symbols 3-Install led lights 4- Install air valves 5-Install wiring harness

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4635-141	Fwd Ceiling Replacement Panel Assembly, LH	1 Ea (1 ea)	90-Start up Operation	5134531
D4646-1	Plenum Cap Assembly	2 Ea (2 ea)	90-Start up Operation	511732
D4652-3	Mounting Nut	2 Ea (2 ea)	90-Start up Operation	5034252
D4652-5	Air Valve, 1.25 Id Disk Type	2 Ea (2 ea)	90-Start up Operation	
D4655-1	Speaker	2 Ea (2 ea)	90-Start up Operation	5128736
D4708-9	Lanyard	2 Ea (2 ea)	90-Start up Operation	5001856
D4728-041	LH Cabin Speaker #1	1 Ea (1 ea)	90-Start up Operation	5018987
D4728-043	LH Cabin Speaker #2	1 Ea (1 ea)	90-Start up Operation	5018999
D4728-059	Cabin Lights Harness	1 Ea (1 ea)	90-Start up Operation	5018999
D4743-1	Speaker Grill	2 Ea (2 ea)	90-Start up Operation	5117744
MS21044-N08	Nut ST303	8 Ea (8 ea)	90-Start up Operation	5027549
MS21919-WDG8	Clamp ST388 ST293	6 Ea (6 ea)	90-Start up Operation	5027546
MS24693-BB51	Screw ST288	8 Ea (8 ea)	90-Start up Operation	5009466
NAS1149DN832J	Washer ST264	8 Ea (8 ea)	90-Start up Operation	5131200
PLT1.5M-M	Tie Wrap ST570	7 Ea (7 ea)	90-Start up Operation	5131246

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D4635-141	1	0	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

D4646-1	2	16	0
D4652-3	2	207	0
D4652-5	2	11	0
D4655-1	2	6	0
D4708-9	2	40	0
D4728-041	1	19	0
D4728-043	1	4	0
D4728-059	1	8	0
D4743-1	2	15	0
MS21044-N08	8	228	0
MS21919-WDG8	6	27	0
MS24693-BB51	8	533	0
NAS1149DN832J	8	1,065	0
PLT1.5M-M	7	2,169	0

Part Specifications

Specifications could not be found.

Plex 10/22/18 11:07 AM Dart.lajeunesse.marie

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AEROSPACE

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Container No: S135599



Part: D4635-041

Job No: 185046

Serial No/Batch: S135599

Revision: F

Inspector:

Exp Date:

Instructions: Various STC's

Date: 12/07/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
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